

Work Order ID 74913

74913

Page 1

Thursday, October 13, 2011 12:26:53 PM

Item ID: D3914-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Long Basket Lid Assembly (350)

Start Date: 10/13/2011 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2011 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-10-13

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: 4115778 0.00
Large Fab

100

Large Fab

Large Fab

Memo

1- assemble ribs, weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

11/10/24 (1x)

11-10-25

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Page 2

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 Start Date: 10/13/2011 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 10/19/2011 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
120									
QC	Memo	0.00							
Quality Control									

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
130									
Powdercoat	Memo	0.00							
Powder Coating	*** mask sides of hinge prior to powdercoat*** Start Time: 8:30 Oven Temperature: 320°F Finish Time: 9:05								

140	Wing Walk as per dwg QSI005 4.4 Batch 1118988	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing	1- Mask data plate and apply wing walk on outside surface of mesh as per dwg 2- Install placard and label as per dwg ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label***								

Handwritten: 11/14/10/25

Handwritten: 1 of 11/10/25

Handwritten: M117338

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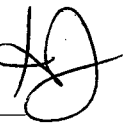
Page 3

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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC3- Inspect Part Finish	0.00							
150		0.00							
QC	Memo								
Quality Control									
160	Identify as per dwg & Stock Location: <u>w/b</u>	0.00							
160		0.00							
Packaging	Memo								
Packaging									
170	QC21- Final Inspection - Work Order Release	0.00							
170		0.00							
QC	Memo								
Quality Control									

11/10/27 
 MF
 11-10-26

W/O:		WORK ORDER CHANGES					
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Picklist Print

Thursday, October 13, 2011 12:26:58 PM

Page 1

Work Order ID: 74913

74913

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2581

Manufactured

No

100

Each

35.0000

2

2

D2581

Mounting Bracket

**

SY 11/10/24

Location

Loc Qty

Loc Code

WA

35

69739

2

70766

2

73079

10

73762

21

(2x)

D3914-1

Manufactured

No

100

Each

3.0000

2

2

D3914-1

Rib

**

SY 11/10/24

Location

Loc Qty

Loc Code

WA

3

74637

3

(2x)

D3914-7

Manufactured

No

100

Each

2.0000

2

D3914-7

Rib

**

B 73 942 (2x) SY 11/10/24

Location

Loc Qty

Loc Code

WA

2

74643

2

W/O:		WORK ORDER CHANGES					
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Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

✓ ***D4016-3***
Hinge Half, Lid

D4016-3 Manufactured No

100 Each 19.0000 3 3

**

SS 11/10/24

Location	Loc Qty	Loc Code
WA	18	
73630	18	
WA005	1	
71941	1	

(3x)

✓ ***D4018-5***
Rib

D4018-5 Manufactured No

100 Each 14.0000 9 9

**

B 74636 (8x) SS 11/10/24

Location	Loc Qty	Loc Code
WA	14	
70758	5	
73943	9	

(1x)

✓ ***D4020-5***
Mesh (350 Basket Long, Lid)

D4020-5 Manufactured No

100 Each 5.0000 1 1

**

SS 11/10/24

Location	Loc Qty	Loc Code
WA	5	
68234	1	
69162	1	
73935	3	

(1x)

✓ ***D4021-3***
Data Plate

D4021-3 Manufactured No

100 Each 6.0000 1 1

**

SS 11/10/24

Location	Loc Qty	Loc Code
WA	6	
73632	6	

(1x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

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74913

Parent Item: D3914-041

D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 10/13/2011

Required Date: 10/19/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041 Manufactured No

100 Each 2.0000 1 1

D4035-041

Lid Rib Assembly, Fwd (350 Basket)

**

11/10/24

Location

Loc Qty

Loc Code

WA

2

63720

0

73634

2

D4035-043 Manufactured No

100 Each 4.0000 1

D4035-043

Lid Rib Assembly, Aft (350 Basket)

**

11/10/24

Location

Loc Qty

Loc Code

WA006

4

73628

4

D2728-3 Manufactured No

140 Each 0.0000 1 1

D2728-3

Dart Logo label

**

(X1) 11/15/2020 11/10/24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

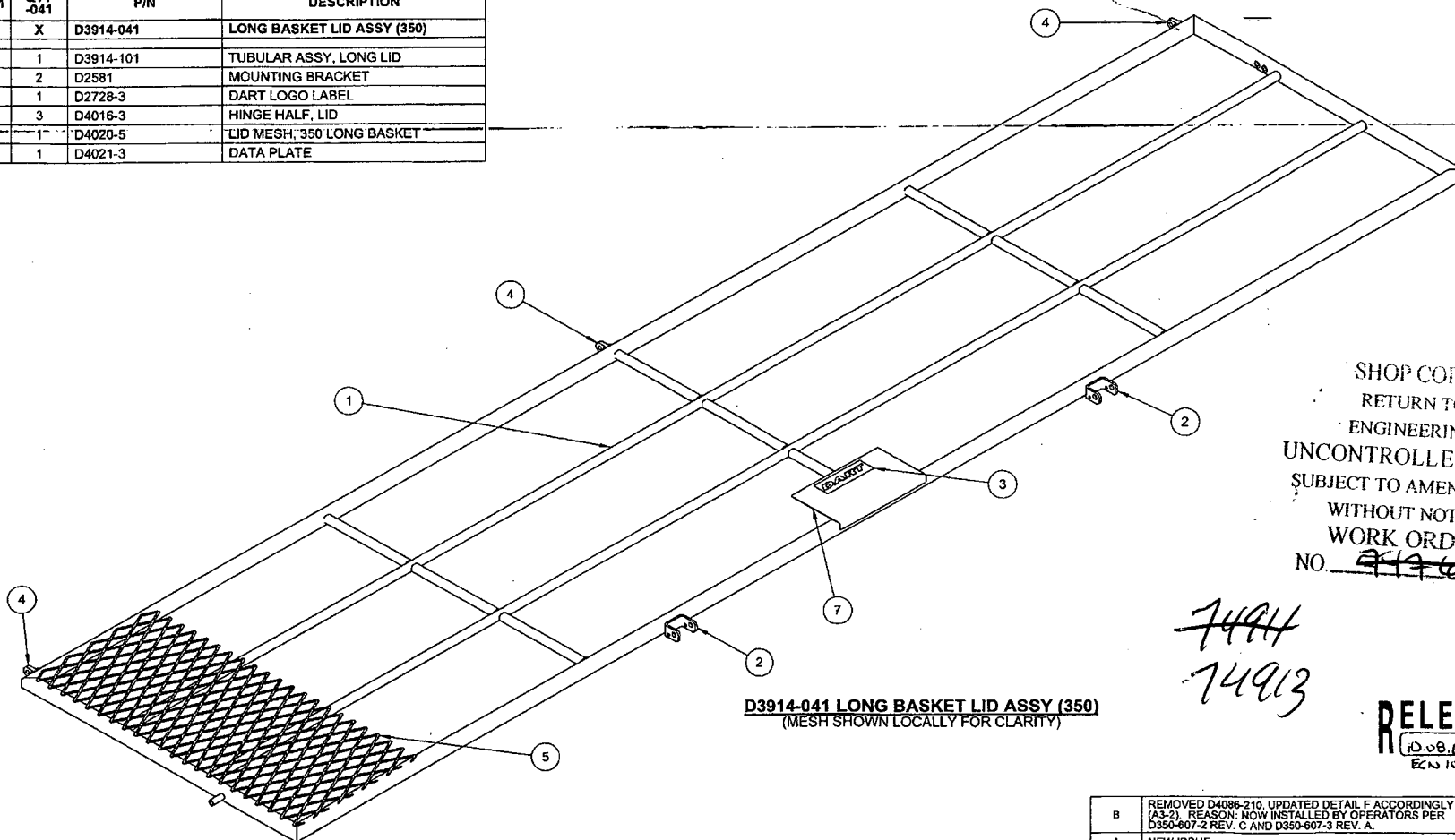
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ITEM	QTY	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 74960 M.L.J

74944

74913

11/10/11

RELEASED
10-08-17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS		
DRAWN	SC		
CHECKED	SC		
MFG. APPR.	SC		
APPROVED	SC		
DE APPR.	SC		
DATE	10.08.05		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWING NO. D3914		REV. B	
TITLE LONG BASKET LID ASSY (350)		SCALE	NTS
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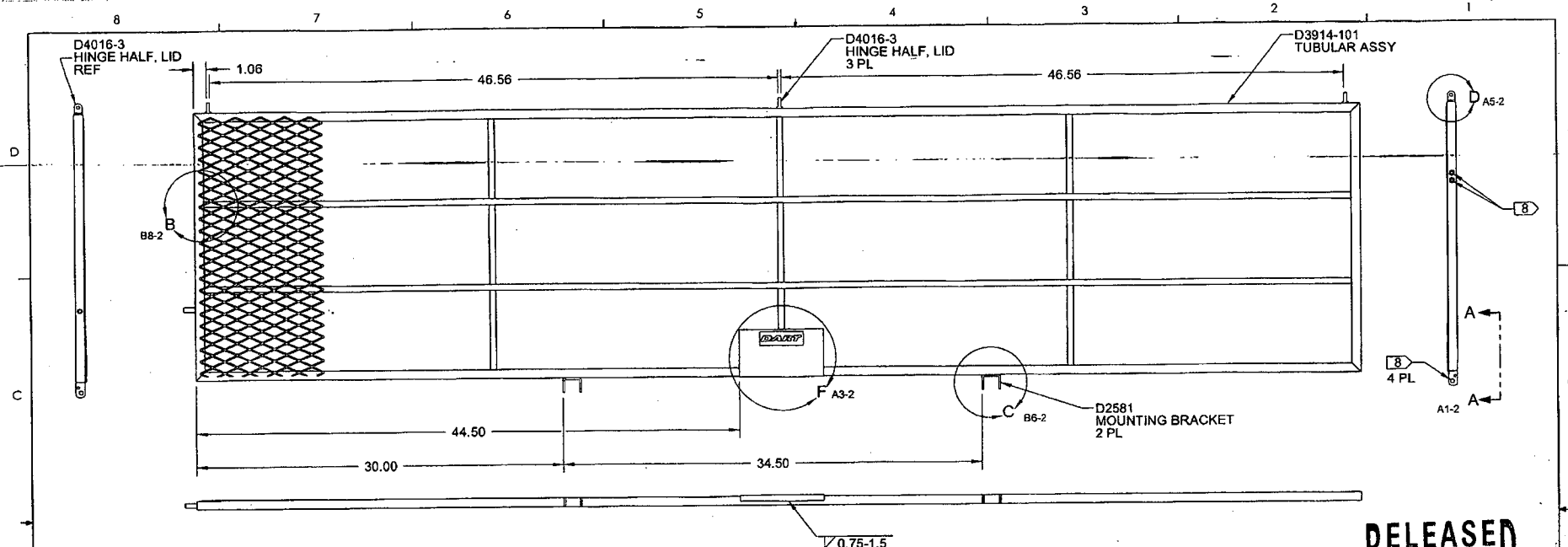
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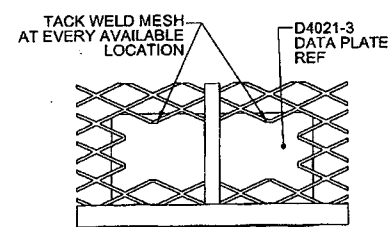
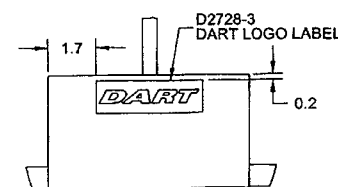
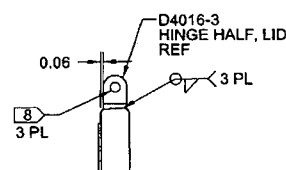
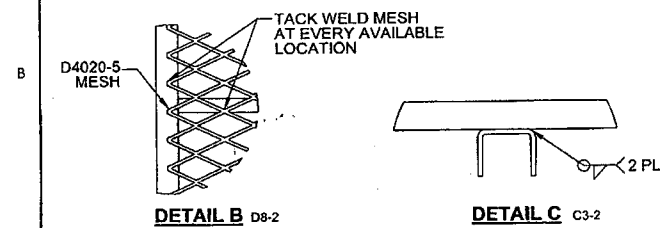
74760

749B



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
10.08.12 CP



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3914	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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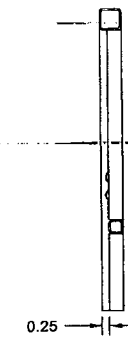
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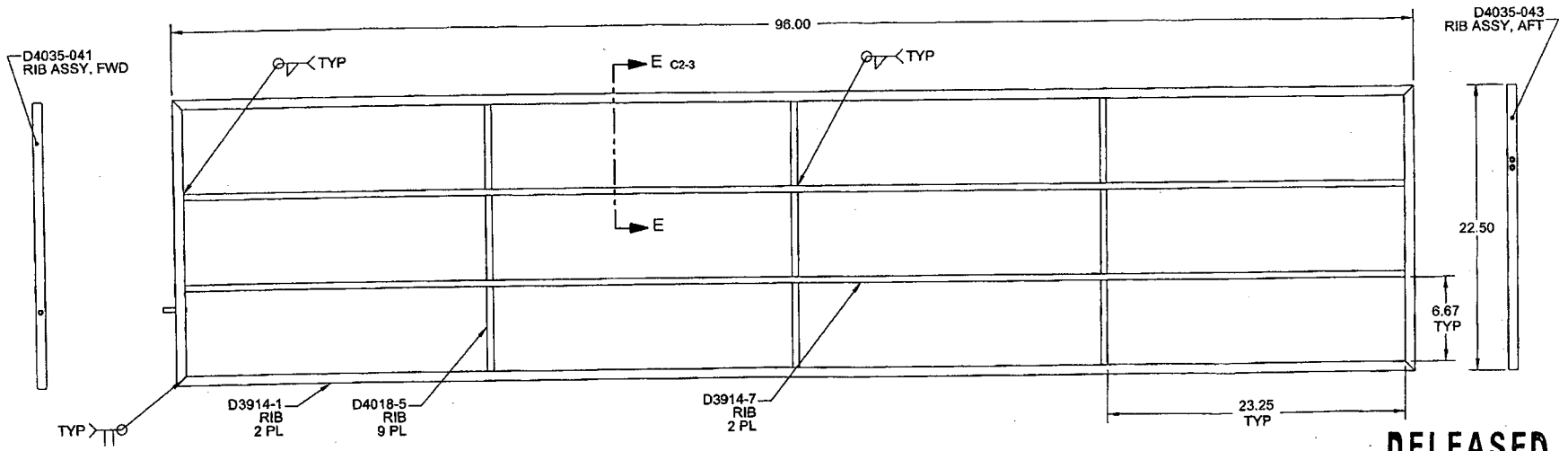
NOTE: Date & initial all entries

24760 74913

ITEM	QTY	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-08-05

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 14.10 lbs
 - 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
 - 9) WELD PER DART QSI 004

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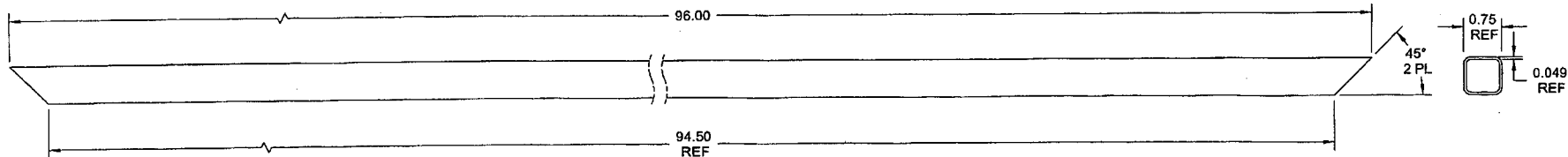
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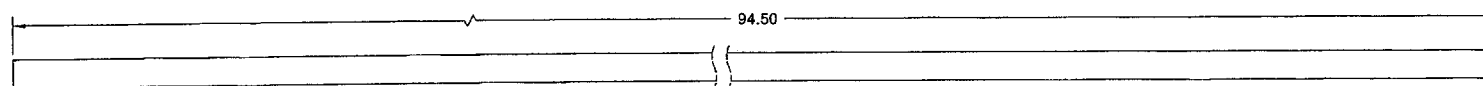
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24760
7491B



D3914-1 RIB



D3914-7 RIB

NOTES:

1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049

-7: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

RELEASED
10.08.12 CP

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